



Dart Hawkesbury
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Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

D4149-1
Job Sheet 168415



Part No: D4149-1

Job Qty: 36 ea

Part Name: Crosstube Lug Plate, Aft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/14/17

Job Tracking No:

Due Date: 12/3/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV C IPP Rev:A 10.06.24 new issue DD ver:EC IPP Rev:B 11.03.03 as per revC DD ver:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	36 Ea		12/2/17	0.00	0.00	Start Up Waterjet		SC 18/01/07
100	Waterjet	36 pcs		12/3/17	0.00	5.50	Waterjet1		SC 18/01/07
110	QC	36 pcs		12/3/17	0.00	0.00	QC2		SC 18/01/07
120	QC	36 pcs		12/3/17	0.00	0.00	QC8		SC 18/01/07
150	Packaging	36 pcs		12/3/17	0.00	0.00	Packaging3	5/088	SC 18/01/07
160	QC21-SA	36 Ea		12/3/17	0.00	0.00	QC21		SC 18/01/07

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S11GA	5	135	0	0

FM 13909-80

6.35

Part Specifications

Specifications could not be found.

Plex 11/14/17 1:58 PM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

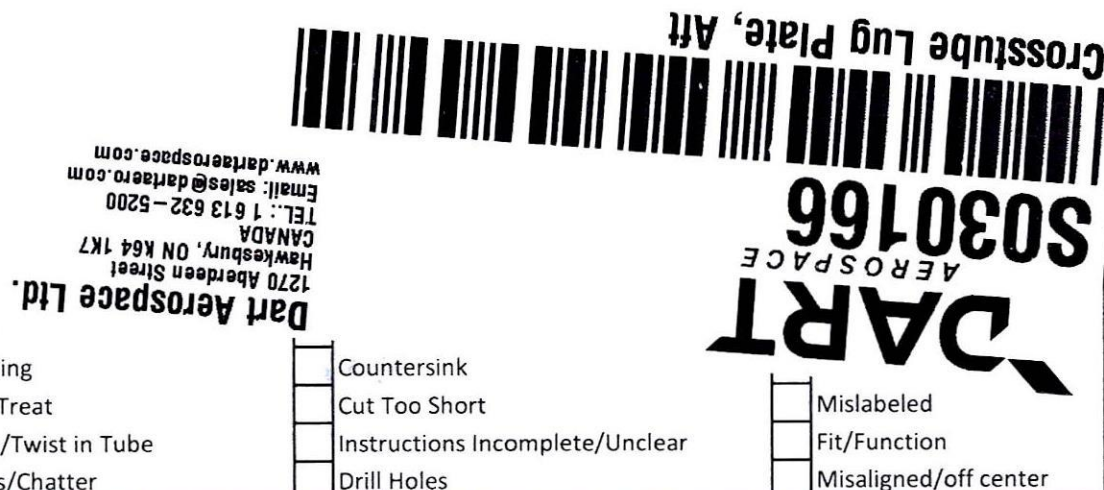
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
Description Work Order Dev		Disposition	Completed By

Job No: 168415
Mfg Date: 01/08/18
Start up Operation
D4149 - 1
PART NO: _____
Revision: _____
Operation: _____
Change No: _____

Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		P ☐ B ☐ C ☐) ☐) ☐) ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____				



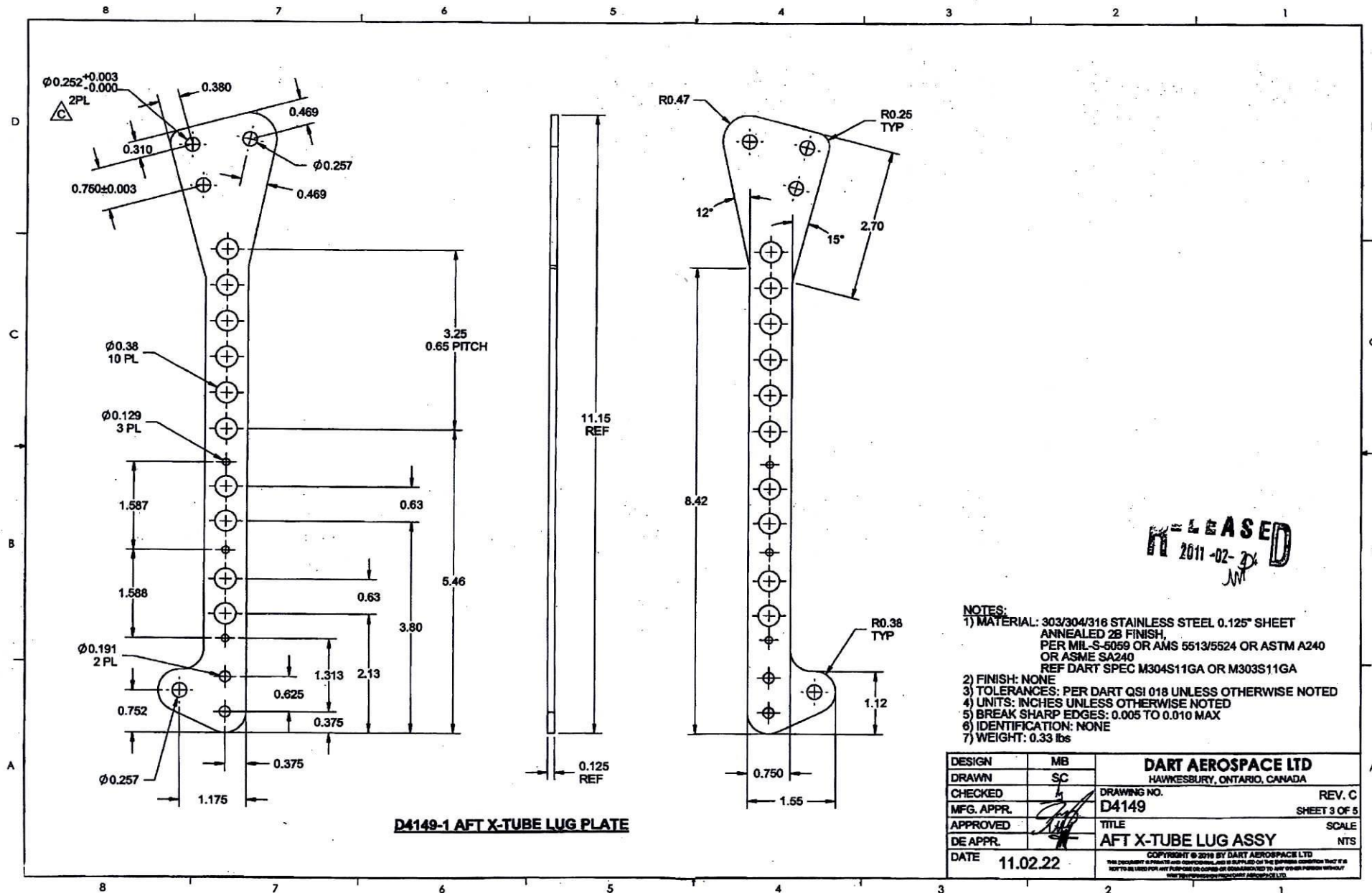
DART AEROSPACE LTD		Work Order:	
Description: Aft Crosstube Lug Plate		Part Number:	D4149-1
Inspection Dwg: D4149	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	Ø0,130			URC-01	
Ø0.191	+0.005/-0.001	Ø0,192			URC-02	
Ø0.257	+0.006/-0.001	Ø0,257				
Ø0.38	+0.006/-0.001	Ø0,379				
0.380	+/-0.010	0,386				
0.469	+/-0.010	0,467				
0.310	+/-0.010	0,316				
0.750	+/-0.010	0,751				
3.25	+/-0.030	3,254				
0.65	+/-0.030	0,655				
0.63	+/-0.030	0,632				
5.46	+/-0.030	5,46				
3.80	+/-0.030	3,799				
2.13	+/-0.030	2,128				
1.313	+/-0.010	1,315				
0.625	+/-0.010	0,626				
0.375	+/-0.010	0,377				
1.175	+/-0.010	1,178				
0.752	+/-0.010	0,751				
1.588	+/-0.010	1,589				
1.587	+/-0.010	1,588				
11.15	+/-0.030	11,158				
0.750	+/-0.010	0,758				
1.55	+/-0.030	1,56				
1.12	+/-0.030	1,128				
8.42	+/-0.030	8,427				
2.70	+/-0.030	2,708				
0.125	+/-0.010	0,117				
Ø0.252	+0.003/-0.000	Ø0,253				

Measured by: SC	Audited by:	Preliminary Approval:
Date: 18/01/07	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	12.02.01	Dimensions updated per Dwg Rev C	KJ	



- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET
ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240
OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.33 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD	